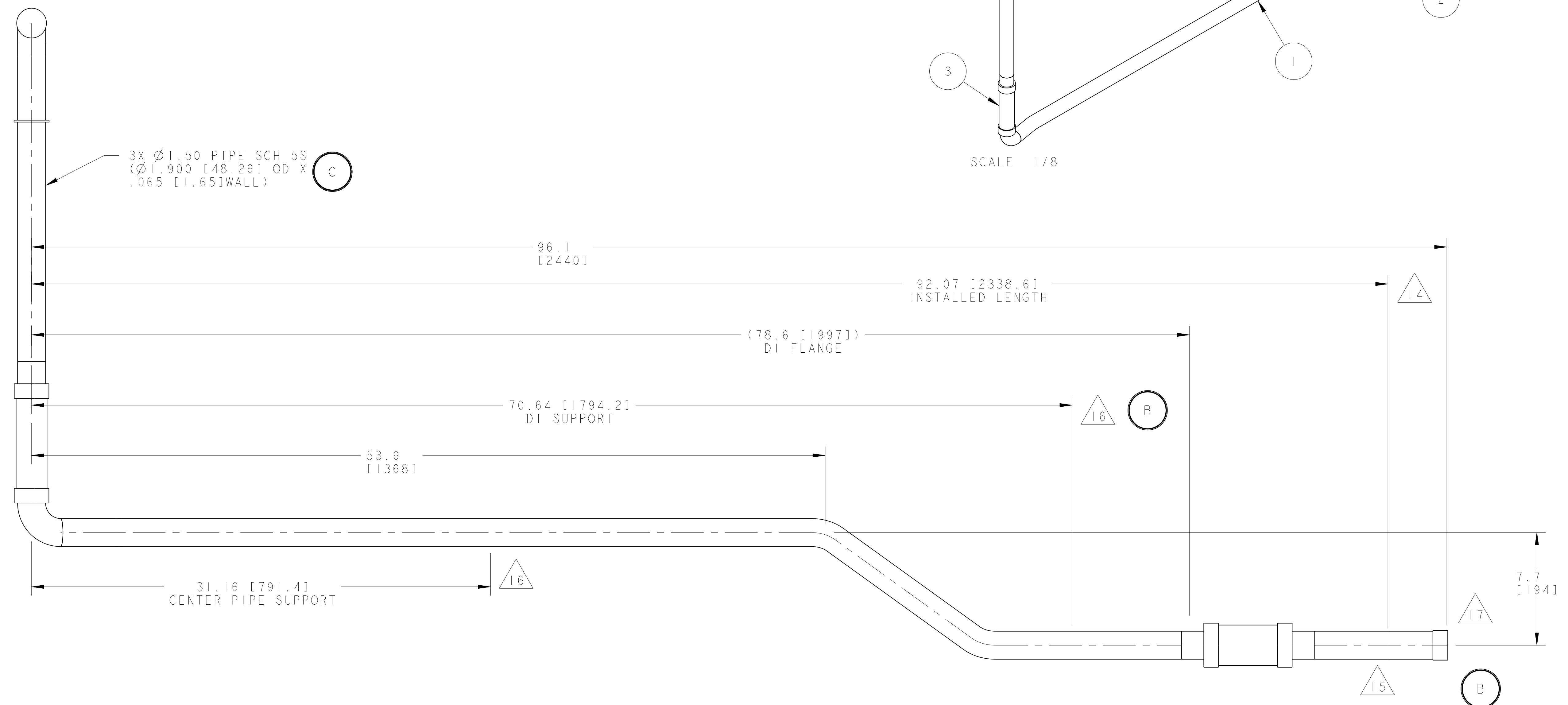
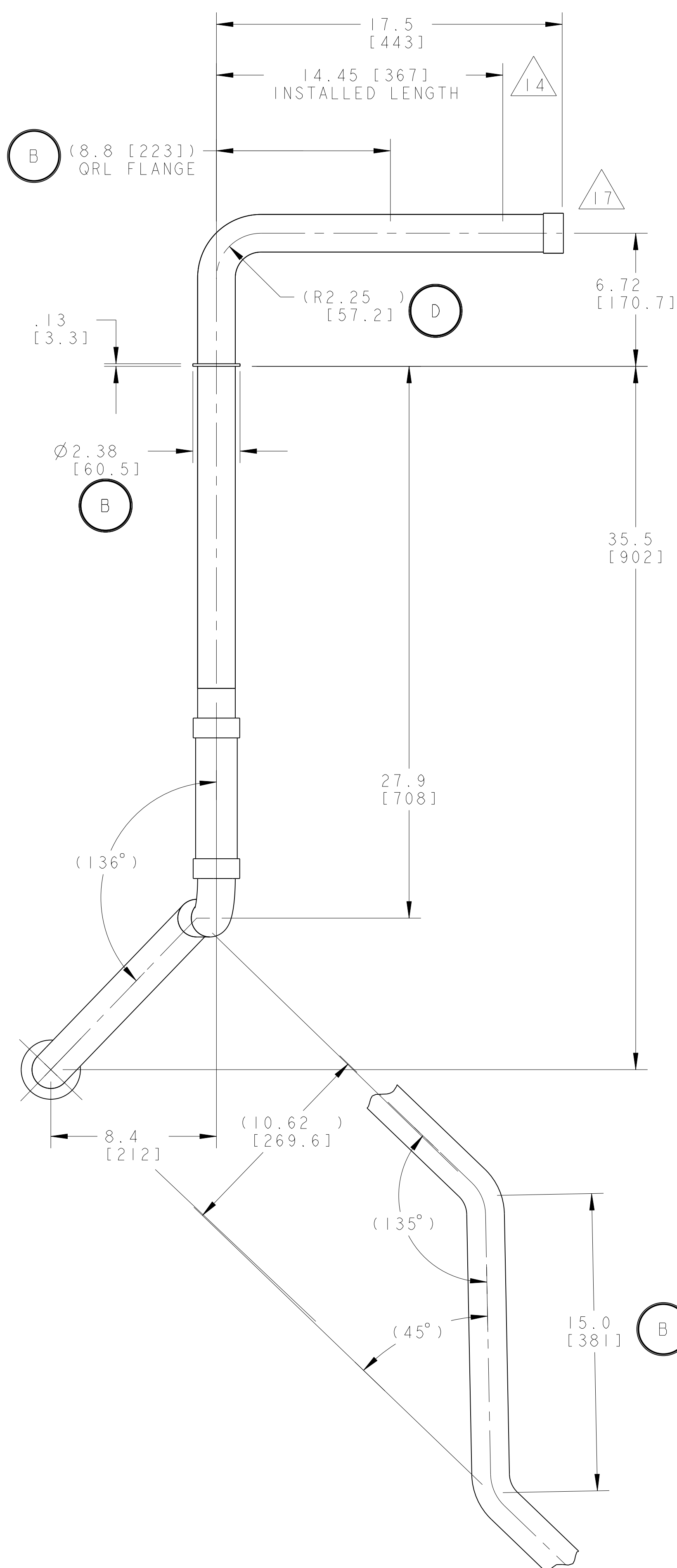
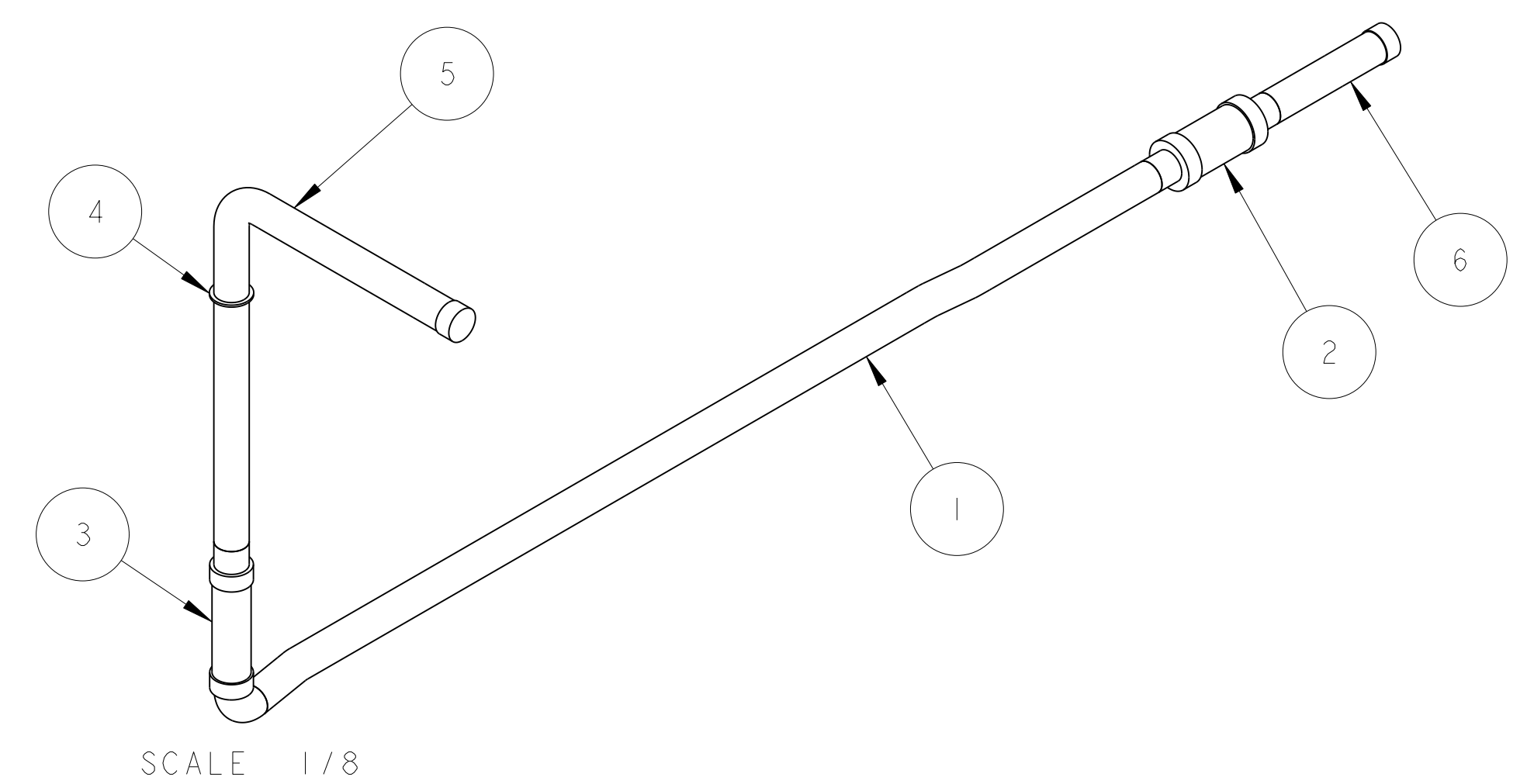
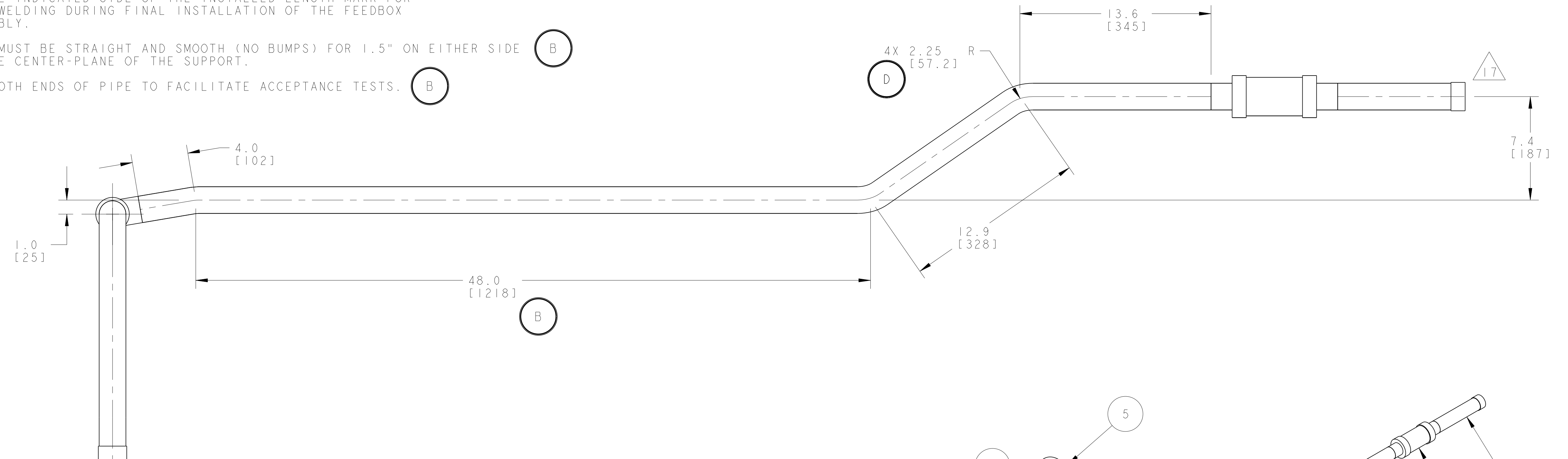


1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN  $\pm .010$ .
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. B

14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063$ ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)



D	R/LM	JPZ	6/9/03	RADIUS 2.25 WAS 2.5; PIPE DESIGNATION	
C	R/LM	-	5/8/03	SKIPPED	
B	R/LM	DPO	11-10-02	CHANGED FLANGE DIAMETER. REVISED DECIMAL PLACES IN TOP VIEW. CHANGED DESCRIPTION CALLOUT FOR BOM ITEMS 5 & 6. DELETED ORL WELD CLEARANCE CALLOUT. ADDED NOTE 16 CALLOUT TO VIEW. ADDED ORL CALLOUT TO DOWN VIEW. REVISED DWG NOTES 13, 15 & 17. MINOR DRAWING DIMENSIONAL CHANGES.	
A	ARRH	DPO	9-16-02	INITIAL RELEASE	
REV	DWG	CHK ZONE	DATE	CHANGES	

UNLESS OTHERWISE SPECIFIED		
TOLERANCES	X.X ± 0.1	FRAC. ± 1/64
	X.XX ± 0.03	Angles ± 1.00°
	X.XXX ± 0.010	FINISH $\sqrt{Ra}$

DO NOT SCALE PRINT

THREADS ARE CLASS 2

CHAMFER ENDS OF ALL SCREW THREADS 30°

CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS

BREAK EDGES .015 MAX. ON MACHINED WORK

REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

IN ACCORDANCE WITH ASME Y14.5 & Y14.1

	6	-	I	PIPE, PER ASTM A312	SS 304L
(H)	5	-	I	PIPE, PER ASTM A312	SS 304L
	4	-	I	SUPPORT COLLAR	SS 304L
	3	-	I	BRAIDED FLEX HOSE, 2"ID x 6.1" LL	SS 300 SERIES
	2	-	I	BRAIDED FLEX HOSE, 2"ID x 4" LL	SS 300 SERIES
	1	-	I	PIPE, PER ASTM A312	SS 304L
	ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
IFIED	<b>SHOP ORDERS</b>				
1/6/64	ACCT NO.	DATE ORDERED	DATE SHIPPED		
1 U.O.#	NO.	BY	RECEIVED BY		
(1/2) INCH	SUBJECT:				
INT	FURNITURE				
	PROJECT TAG				
	METHOD				
	QUANTITY N/A				
THRU 8/2/63	PROJECT NAME				
	DATE 15-Dec-61				
	MICROFILMED:				
	ASSEM				215226
	PATENT CLEAR:				
	DESIGN ACCT: 575LC52				LH2003
	DWG. NO.				215226
	SCALE: 1/4"				DWG. NO.
	SHEET 1 OF 1				SIZE: REV.
	DWG. NO.				215226
	DWG. NO.				215226